

# Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG	
Job Number	: 32163		Part Number	: D22301	
Estimate Number	: 10255		Drawing Number	: D2230 REV F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/3/2007	S.O. No.	: N/A	Drawing Revision	: F
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/20/2007	
Previous Run	: 30992		Qty:	200	
Written By			Um:	300	
Checked & Approved By			Each		
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 21.5145 f(s) Lug Extrusion D2423 Extrusion Batch: 300602	c207/05/22
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch:	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		RG	Issue P10-3812
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling	machine pending D 2230 RCV. F
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Received + inspect	37
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>for tinted damage</i>	
5.0	QC5	SECOND CHECK	
		Comment: SECOND CHECK <i>inspect level 5</i>	counted X 197



Date: Thursday, 5/3/2007 11:29:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 32163

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(197 counted)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M 07 07 16



7.0 QC3

INSPECT WORK TO CURRENT STEP



(197X)

Comment: INSPECT WORK TO CURRENT STEP

M-F

07/07/17

8.0 POWDER COATING

POWDER COATING



(197)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

Edm-f 07-07-17

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(197)

Comment: INSPECT POWDER COAT

F-L

07/07/17

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

E/S 07/07/27

counted

200

(200)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/07

Job Completion



JUL 07-07-27

3344

Date:

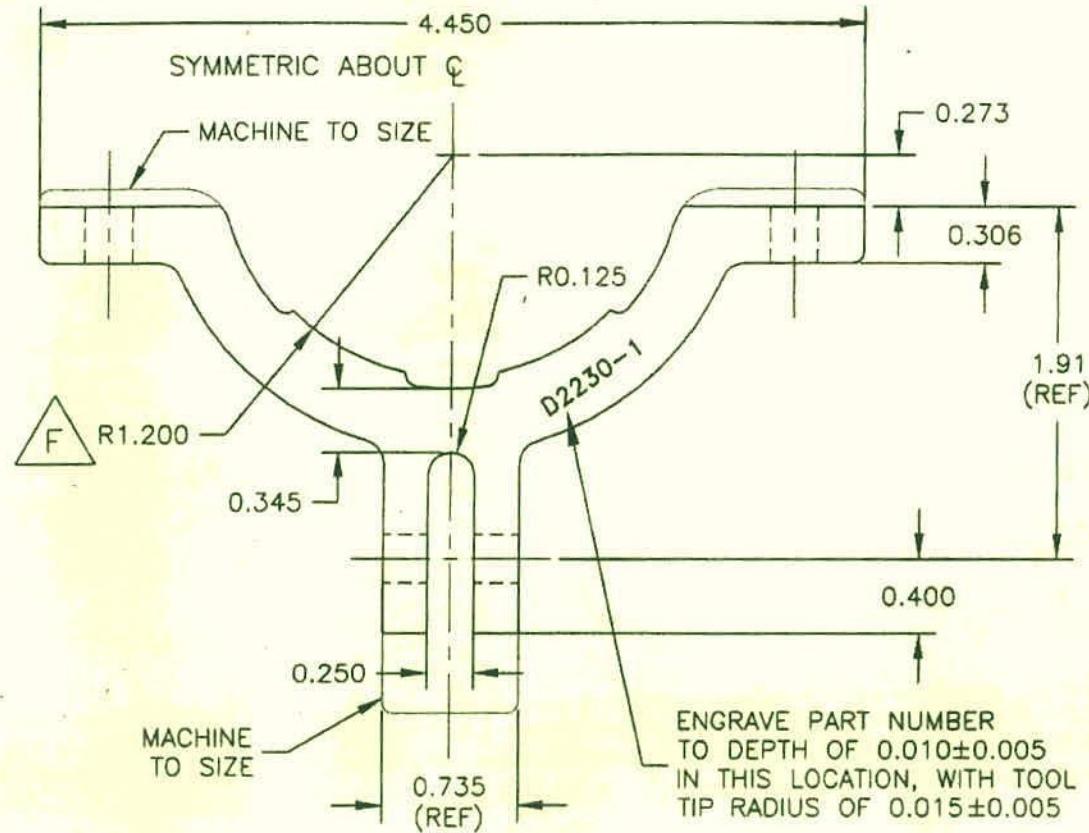
1910

1910

1910

**DART**

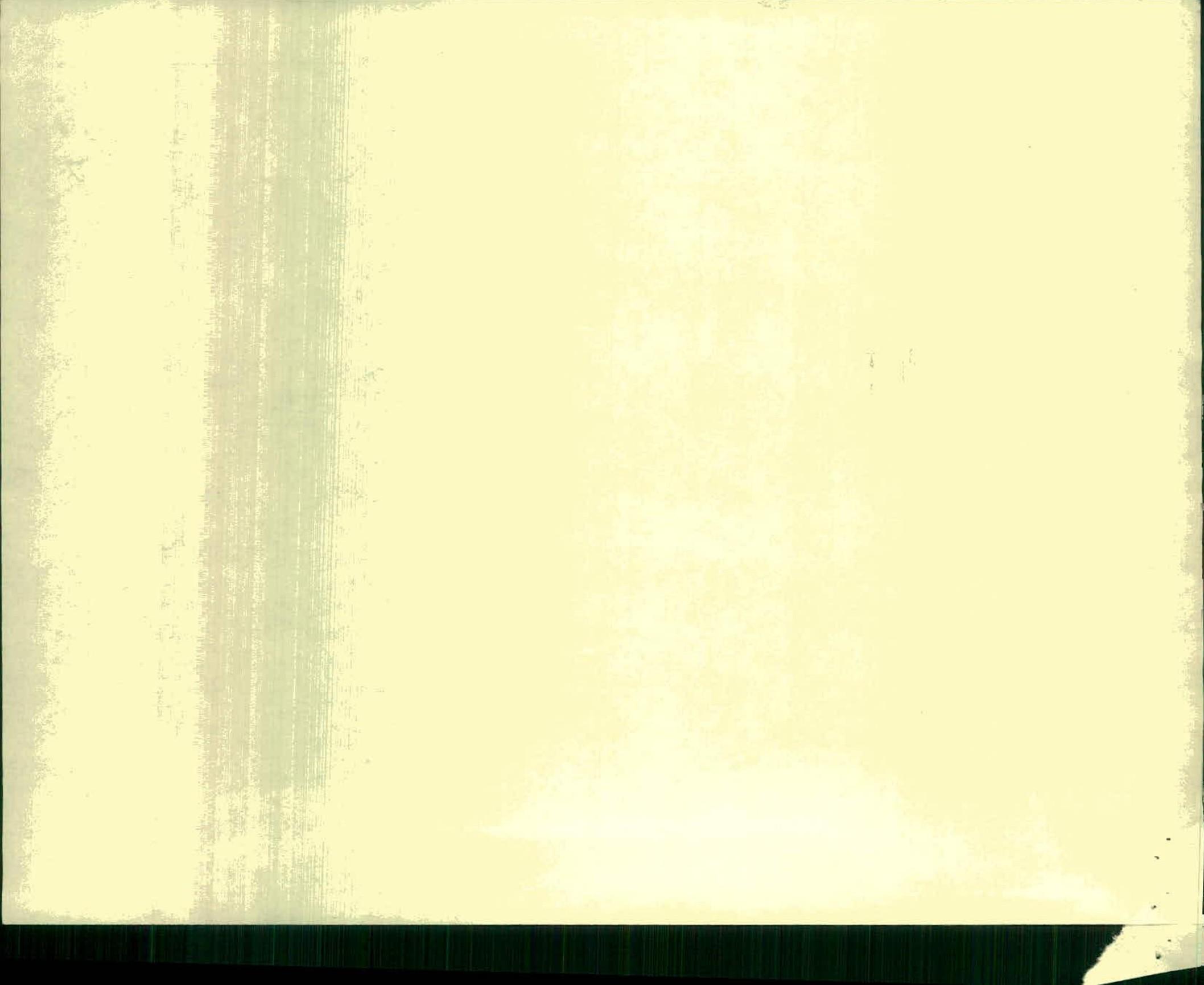
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE		TITLE MOUNTING LUG SCALE 1:1
99.12.13		
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED  
99.12.21 DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32163

3.442  
257  
59

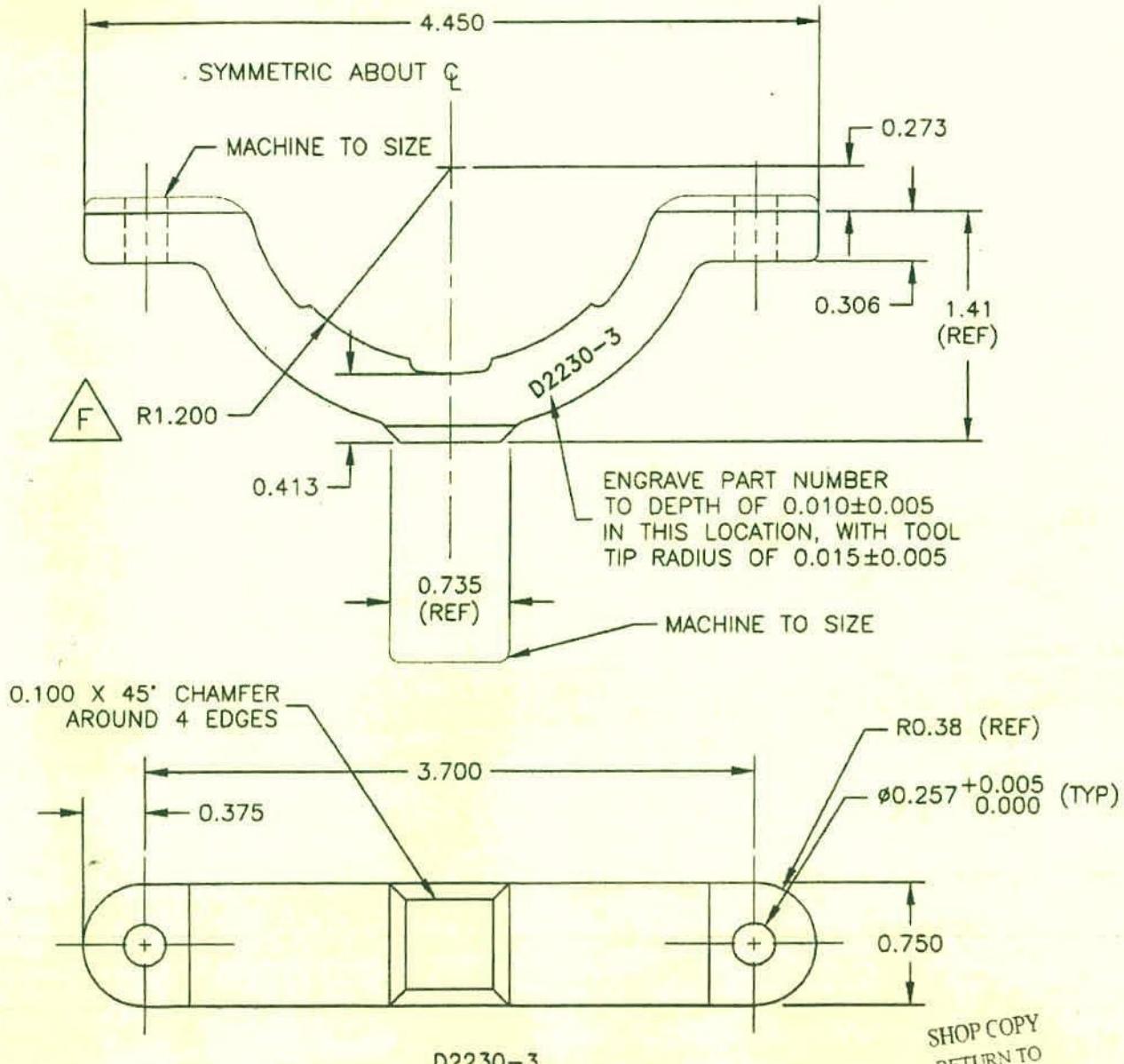
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**DART**

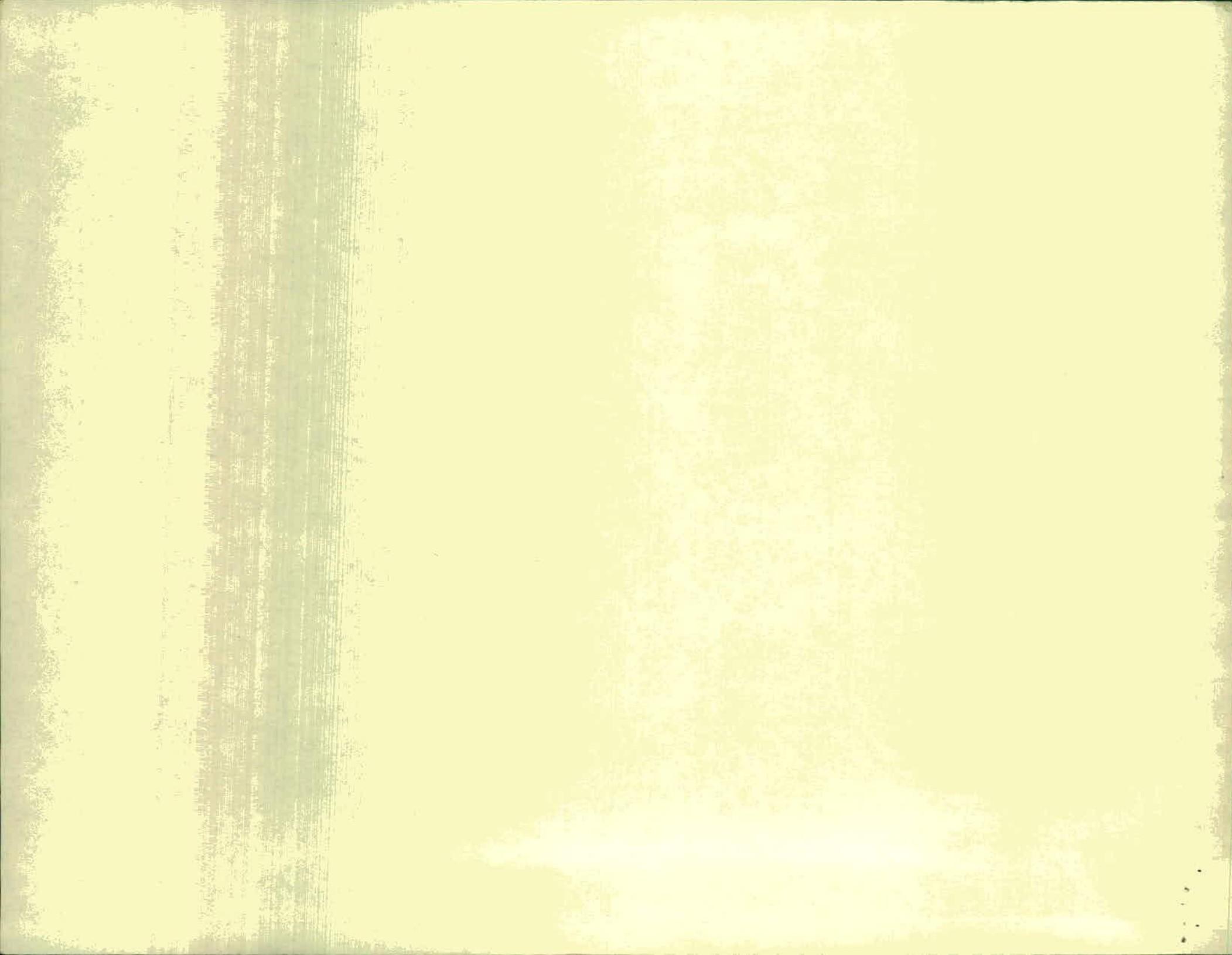
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F
DATE		SHEET 2 OF 2

99.12.13 TITLE MOUNTING LUG SCALE 1:1

RELEASED  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
 BREAK ALL EDGES 0.000-0.015  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 32163



# METEC METAL TECHNOLOGY INC.

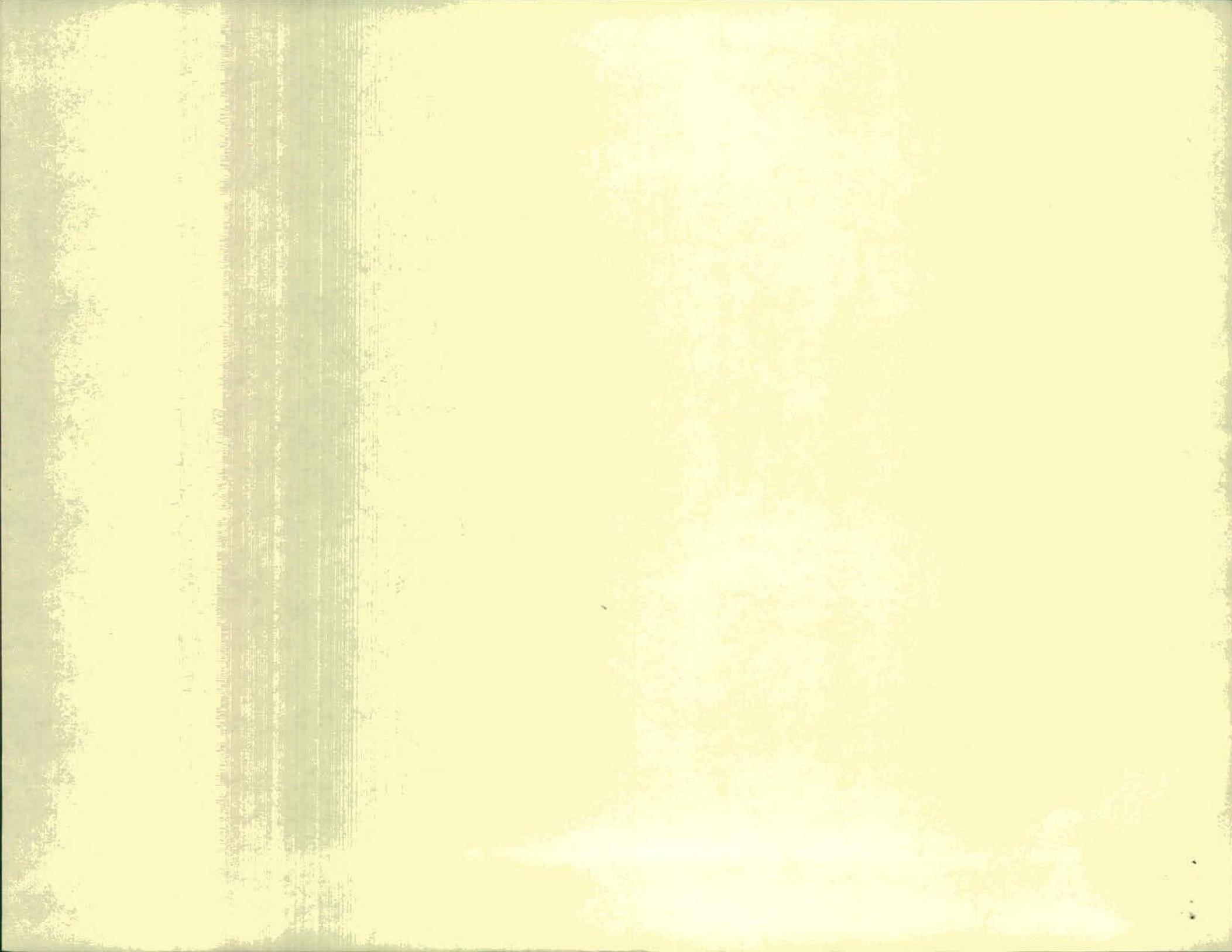
20 Terry Fox Drive  
 Vankleek Hill, Ontario K0B 1R0  
 Tel: (613) 678-3957  
 Fax: (613) 678-3956

**Delivery Slip No.:** 15993  
**Date:** Jul 09, 2007  
**Page:** 1

<b>Sold to:</b>		<b>Ship to:</b>
Dart Aerospace Ltd.  Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 3812		<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> our truck		<b>Ship Date:</b>

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug B32163	Each	370	200 ✓	
D2731-7	LUG B32387	Each	64		
D2731-7	LUG B32388  Cut from D2423 B30062 extrusion	Each	64		

Thank you for your order!





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY    PART NUMBER

200              D2230-1

PART NAME

Lug B32163

P.O. NUMBER

3812

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

*Shigie Walz*  
Shigie Walz

Vankleek Hill, July 9, 2007



